

AMTEC 2 CAST IRON AC/DC REVERSE ELECTRODE



General Characteristics

Special electrode for cold welding of spheroidal graphite iron, grey cast iron, ductile, nodular and malleable cast iron. Extraordinary high strength combined with excellent welding properties makes this electrode specially suitable for joining cast iron to steel. Despite high strength, the welds and border zones are still machinable if sufficient absorption has taken place and the work piece has cooled off slowly enough. Also ideally suited for the repair of mechanite dies.

Tensile Strength - 75,000 PSI
Elongation - 23%
Hardness (HB) - Approx. 180
Brinell

Diameter		Amps (approx.)
(Inch)	(MM)	
3/32	2.5	40-70
1/8	3.25	70-110
5/32	4.0	90-130
3/16	5.0	110-170

Procedure

Remove thick oil and dirt from the welding zone; keep a short arc. Deposit short beads (30-50mm, 1.25-2 inches) It is recommended to peen deposit to relieve weld stress. The heating of the work piece, due to the welding operation, should not be so severe that it is not possible to touch the component with one's hand. It is permissible to preheat up to 200° F (390°). However, this temperature must be maintained during the welding operation.

Application

For the repair of oily and worn castings, furnace grates, valve housings, heavy cast iron equipment, large foundry fills, joining ductile iron, and other cast iron alloys to steel. It is often used in combination with Amtec 3 Cast Iron, since Amtec 2 builds up faster and Amtec 3 is used for the final pass for best machinability. It is also used for cold welding of grey cast iron and malleable cast iron.